

Date: Wednesday, 9/12/2007 12:10:55 PM  
 User: Kim Johnston

## Process Sheet

41

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKID RH 206L1,L3,L4&407  
 Job Number : 34584  
 Estimate Number : 10328  
 P.O. Number : N/A Part Number : D206642512  
 This Issue : 9/12/2007 S.O. No. : N/A Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : K  
 Previous Run : 34583 Material : N/A  
 Due Date : 10/10/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 07.09.12  
 Comment : Est Rev: B 05.09.23 Revised per D206-642 Rev. J KJ/JLM  
 Est Rev: C 07-02-23 As per IIN D206-642 Rev K JLM  
 est rev D 07.06.06 added K642-512 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-512 CHG003

07/10/05

2.0 34584A FLOAT SKIDTUBE ASSEMBLY

E



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

D206-642-541 B 34584 A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K642 512 saddle kit 642-511

E



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

saddle kit 642-512

batch: 346226

7/10/05 se

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

E 07/10/05

334584A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 9/10/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:10:55 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID RH 206L1,L3,L4&407

Job Number: 34584

Part Number: D206642512

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-512

Location: \_\_\_\_\_

*7/10/5 SD.*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*①*

Comment: FINAL INSPECTION/W/O RELEASE

*207/10/09*

Job Completion



*6 07-1005*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number : 34584  
Estimate Number : 10328  
P.O. Number : Part Number : D206642512  
This Issue : 9/12/2007 S.O. No. : Drawing Number : N/A  
Prsht Rev. : NC Project Number : N/A  
First Issue : / / Type : LANDING GEAR Drawing Revision : K  
Previous Run : 34583 Material :  
Written By : Due Date : 10/10/2007 Qty: 1 Um: Each  
Checked & Approved By : *[Signature]*  
Comment : Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM  
Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM  
est rev D 07.06.06 added K642-512 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-512 CHG003

*07.09.17*

2.0 34584A FLOAT SKIDTUBE ASSEMBLY



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

D206-642-541 B

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K642 512 saddle kit 642-511



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

saddle kit 642-512

batch: \_\_\_\_\_

REFERENCE ONLY

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SR

Dart Aerospace Ltd.

41

Date: Wednesday, 9/12/2007 12:11:33 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE ASSEMBLY  
 Job Number : 34584A  
 Estimate Number : 10309  
 P.O. Number : N/A Part Number : D206642541  
 This Issue : 9/12/2007 S.O. No. : N/A Drawing Number : D3274 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D  
 Previous Run : 34583A Material : N/A  
 Due Date : 10/10/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 07.09.12  
 Comment : Est Rev: B 05.09.23 Revised per D206-642 Rev. J KJ/JLM  
 Est Rev: C 07-02-23 Added SS Wearplates & Gaskets JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D206-642-541 CHG003

N/A

2.0 D26001190 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-190 3" OD Tube

B31032

DP 7-9-18

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

2-Drill #40 Aft cap pilot hole using DT8025

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 7-9-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34584A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

JD 7-8-18

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 12/1/18

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 12/1/19

7.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web 33878

DP

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

3-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

4-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

Sikaflex expire date:

Start: 7-9-19

Finish: 7-9-20

(Adhere for 12 hours)

105488

8-7-1

Time: 11:43

Time: 3:43

DD 7-9-19  
SLR 7-9-19

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

All nuts go through and align



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34584A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

\*\*\*\*\*Verify dimensions before and after cutting\*\*\*\*\*

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

4- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2  
OPEN HOLES TO .297"

5-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

6- Countersink crossbolt spacer holes as per Dwg D3274

11.0

QC5

INSPECT WORK TO CURRENT STEP



*Tube length  
170.625*



Comment: INSPECT WORK TO CURRENT STEP

*Co 07/09/25*

12.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3285-1

Fwd Cap

*B 33374*

*BE 07-09-25*

13.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 D2649

Crossbolt spacer

*B 33214*

*BE 07-09-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34584A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

*B 33429*

*BE 07-09-25*

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod *m/105138*

*BE 07-09-25*

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod *m/105138*

*BE 07-09-25*

3-Grind welds flush to Fwd cap on top surface only.

*BE 07-09-25*

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

*7-9-26*

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Er 06/9/26*

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-09-27*

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*BR 07-09-27*

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*MS 07-10-01*

*(1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34584A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate B334134

BR

21.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet M103525

BR

22.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet M15918

BR

23.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Insert

Batch: M105709

BR

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 M104161

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R Sikaflex-291 M106469

Sikaflex expire date: 05-01

BR 07-10-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34584A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Inspect Nut Plate & Inserts

En 02/10/02 ~~ED~~

26.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)  
BOLT  
Batch: M 105 143 ~~24~~ M 105 810 ~~6~~ BR

27.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B34624

FL 07/10/04 ~~10~~

28.0

D353523

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B32735

BR

29.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B32736

BR

30.0

D353539

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
Batch: B33409 33440

BR

31.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
GASKET  
Batch: B33964

BR

BR 07-10-02



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Wednesday, 9/12/2007 12:11:34 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 34584A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D353623

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B33965

BR

33.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B33659

BR

34.0

D353639

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B33966

BR

35.0

D35371

WEARPAD



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

WEARPAD

Batch: B33967

BR

36.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B33285

BR

37.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

80 AN960C10L

Washer

M 104537

BR

38.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 NAS1515H3L

Washer

M 10548

BR

BR 07-10-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 34584A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring

*B 33433*

*BR*

40.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt

*M 18918*

*BR*

41.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416 Washer

*M 100993*

*BR*

42.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

*B 33289*

*BR*

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291

Sikaflex expire date:

*M 105469*

*08-01*

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3

Batch:

*M 109161*

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

*BR / FL 07/10/07 (P)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 8/11/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 34584A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

Sikaflex expire date:

M105469  
08-01

FL/BR 07-10-04

(P)

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/10/04

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: \_\_\_\_\_

34584

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/07

Job Completion



07-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <b>CP</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3274</b>	REV. D SHEET 1 OF 4
DATE <b>06.12.19</b>		TITLE <b>SKIDTUBE ASSEMBLY</b>	SCALE <b>NTS</b>
<b>A</b>	<b>04.03.15</b>	<b>NEW ISSUE</b>	
<b>B</b>	<b>04.08.09</b>	<b>MOVE SADDLE HOLE: 42.14 WAS 42.76</b>	
<b>C</b>	<b>05.03.16</b>	<b>ADD -043; NEW INSERTS</b>	
<b>D</b>	<b>06.12.19</b>	<b>NEW INSERTS, SS WEARSHOE + GASKET</b>	

**RELEASED****07.02.12**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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WORK ORDER  
NO. **34584A**

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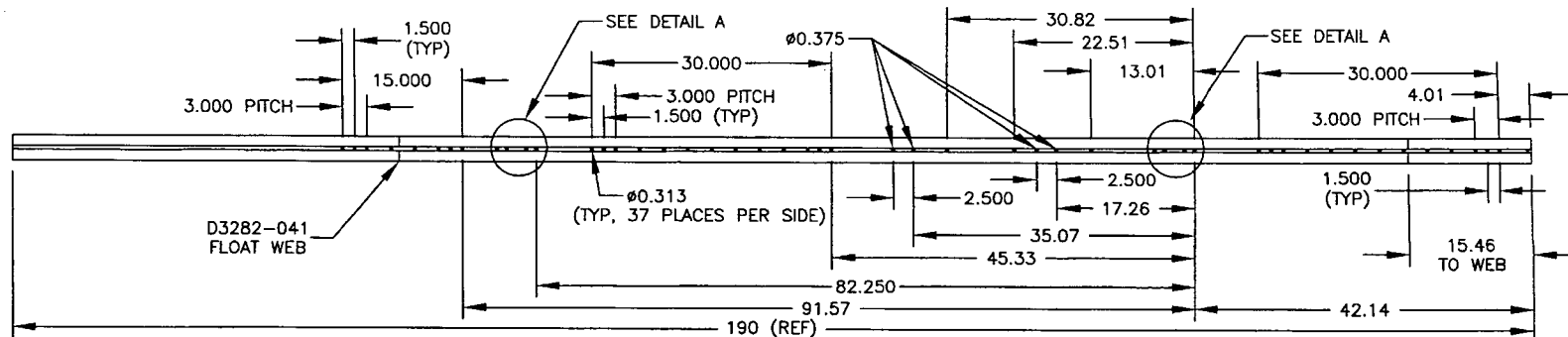
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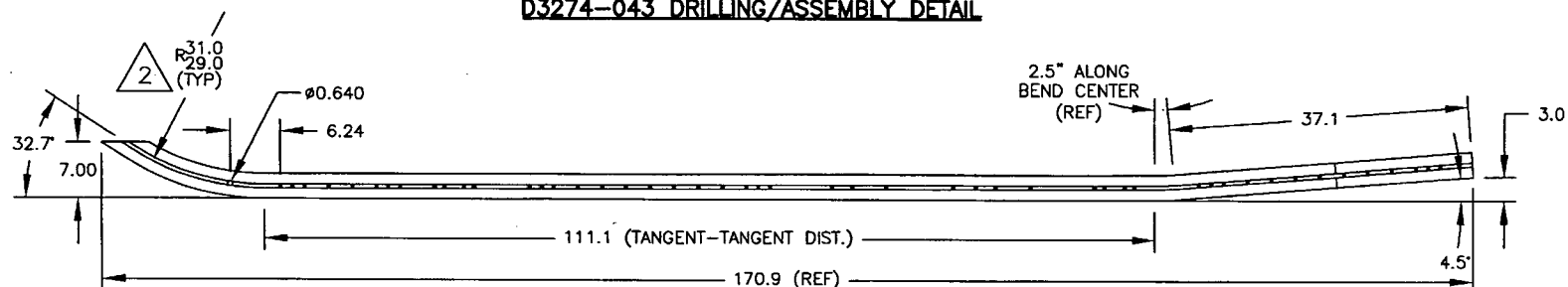


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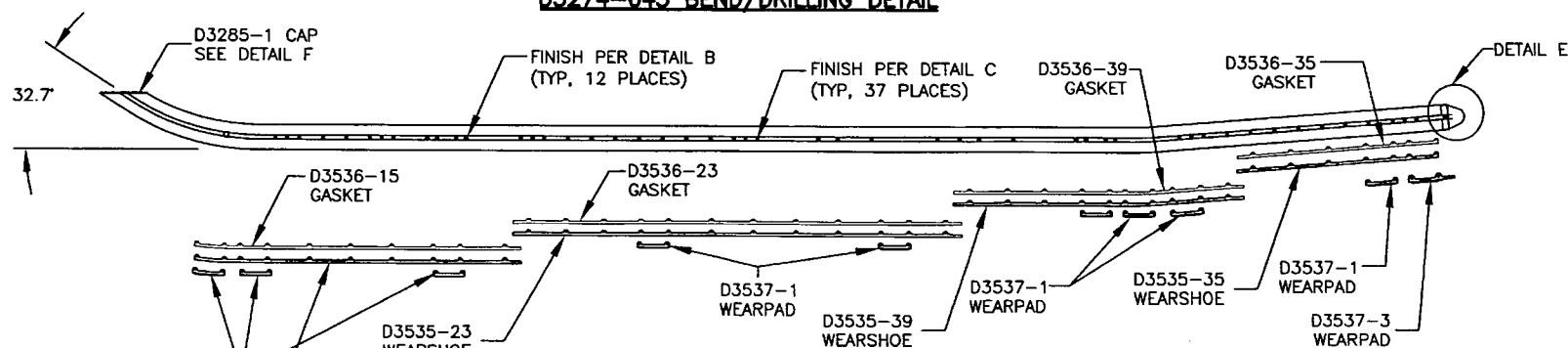
1:15



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07-02-12

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345844

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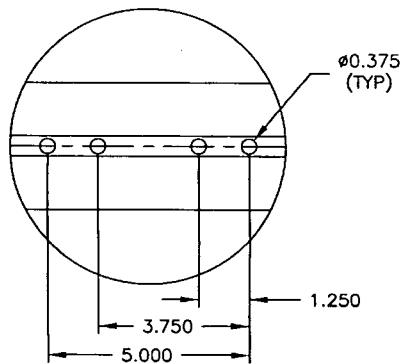
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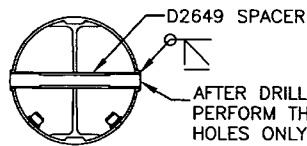
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CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 3 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

# **DETAIL A: DRILL DETAIL**

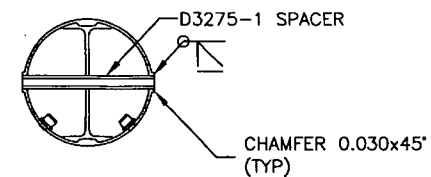


# **DETAIL B** FOR 0.375 HOLES ONLY

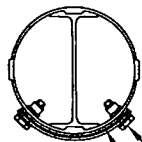


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

# **DETAIL C** FOR 0.313 HOLES ONLY



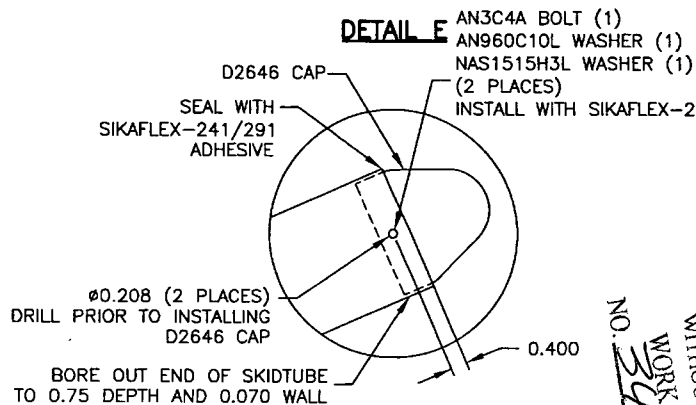
# **DETAIL D**



- ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)

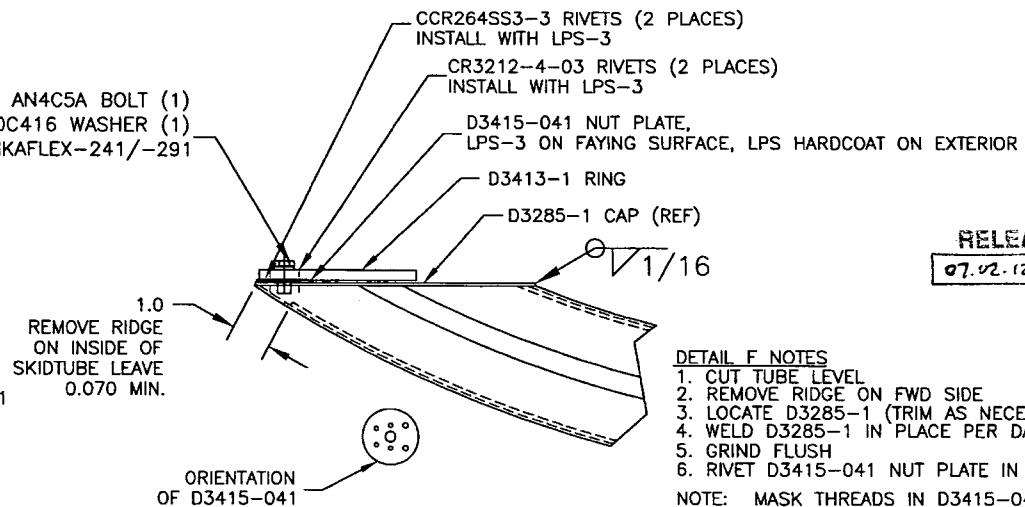
GASKET/WEARSHOE/WEARPAD (REF)

# **DETAIL E**



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# **DETAIL F: END FINISHING DETAIL**



# **DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

RELEASED  
07.02.12

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		CHECKED	APPROVED	D3274	SHEET 4 OF 4
		DATE	TITLE		SCALE
		06.12.19	SKIDTUBE ASSEMBLY		1:3

NO. 128

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure tig  
Part number and Job number D206642541 / B34583 A

TEST WELDS REQUIRED

BASE METAL Aluminium WELDING PROCESS tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

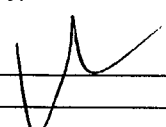
Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-09-26 Qualifier P.D.J.

Date: Thursday, 11/10/2007 2:26:44 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-642
Job Number	: 35132		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: Z_CUSTOM
This Issue	: 11/10/2007 S.O. No. :	Drawing Number	: ECN 1046-PAPERWORK
Prsht Rev.	: NC	Project Number	:
First Issue	: // Type : LANDING GEAR	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 18/10/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 REMOVE FROM STOCK:

D206-642-111 15614 15615

D206-642-112 10319 25504

D206-642-141 9275 18613

D206-642-211 33078 32559 32565-33795-33776

D206-642-212 32257 32567-32566-32568-33079-33080-33242

D206-642-213 19735

D206-642-214 24414-24484-28083-29084-32983-32984

D206-642-241 28097-28604-33211-33342

D206-642-311 28847

D206-642-312 29741-15649-29742-29744

D206-642-341 24441-15649-29742-29744

D206-642-341 34557-34056-34555-34556-32495-31980

D206-642-411 34132

D206-642-411BL 34564-34563-34562-34060-34054-32502-34058

D206-642-412 34735

D206-642-412BL 34735

D206-642-441 31066-30940-30260-30265-24239

D206-642-511 34582-34579-33848-34581

D206-642-512 34586-34584-34583-

D206-642-513

D206-642-514

D206-642-541

D206-642-611

D206-642-612

ADD NEW PAPERWORK EASA.IM.R.S.01320 REV.1  
 PER ECN 1046

1-11-09 SP